

Work Order ID 143948-2

143948

Page 1

March 28, 2016 2:59:15 PM

Item ID: D212-725-1-905

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heater Bleed Air Tube

Start Date: 4/1/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/14/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: SM

Date: 20160328 Soling:

Date:

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4219

A

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Form as per Dwg D212-725-1 & Template DT8907

4 FF APR 28 2015

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

④ 160502 10

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Flare and Install Sleeves & Nut as per Dwg D212-725-1.

4 FF SEP 19 2016

Work Order ID 143948

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143948

Page 2

Item ID: D212-725-1-905

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heater Bleed Air Tube

Start Date: 4/1/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/14/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(4)			DAS 38 9-89 SEP 22 2016
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST 156A</i> Memo	0.00 0.00				4	SEP 26 2016		DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						16/9/26 <i>[Signature]</i>	DAS 21 9-89 SEP 26 2016

Picklist Print

March 28, 2016 2:59:14 PM

Work Order ID: 143948

143948

Parent Item: D212-725-1-905

D212-725-1-905

Parent Item Name: Heater Bleed Air Tube

Start Date: 4/1/2016

Required Date: 4/14/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-01-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-16J		Purchased	No			120	Each	2.0000	2	10			

AN818-16.I

Nut

FF 16-9-26

Location	Loc Qty	Loc Code
ST324	2	
122807	2	

M304TR1.000W.049

Purchased

No

100

f

86.9285

3

15.78947

M304TR1 000W 049

304 RD Tube 1.00 x .049W

FF 16.9.26

Location	Loc Qty	Loc Code
GA002	86.928547	
125250	53.244247	
m130551	33.6843	

MS20819-16J

Purchased

No

120

Each

0.0000

2

10

MS20819-16.I

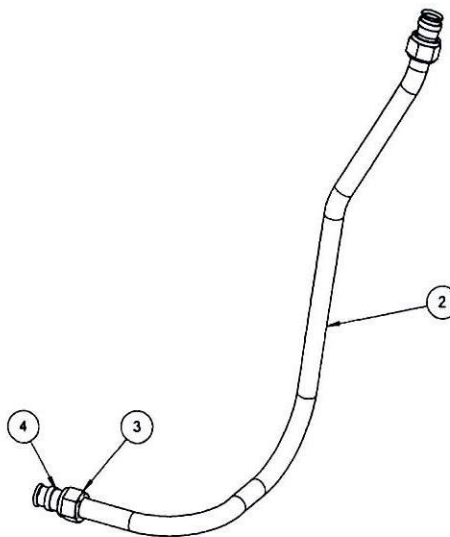
Sleeve

FF 16-9-26

134501	10
122807	9x
134502	

Pulled at split #1
work order.

ITEM	QTY -905	PART NUMBER	DESCRIPTION
1	X	D212-725-1-905	TUBE ASSEMBLY
2	1	D212-725-1-029	TUBING
3	2	AN818-16J	NUT
4	2	MS20819-16J	SLEEVE



D212-725-1-905 TUBE ASSEMBLY

NOTES:

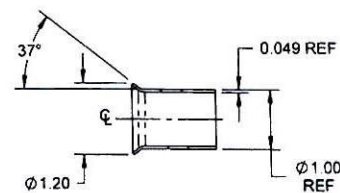
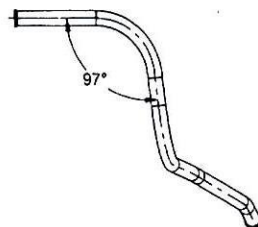
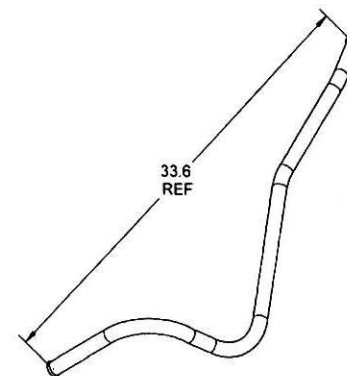
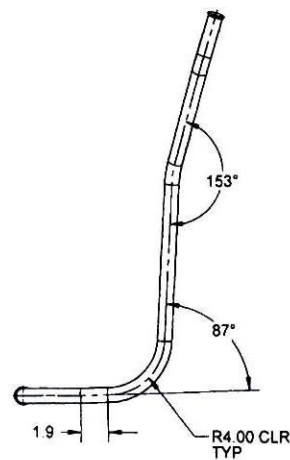
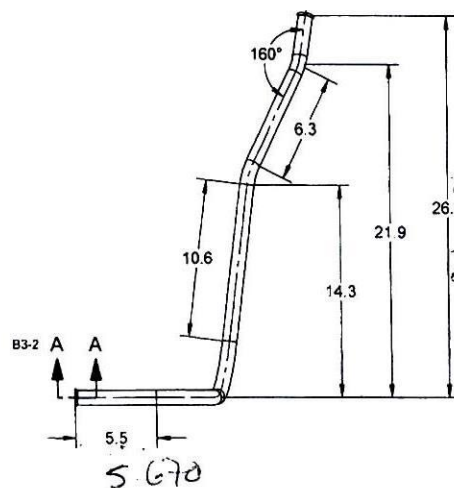
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.41 lbs

RELEASED
2011-08-25
MD

20160329

SH 143948

A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4219	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLY	NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



C7-2
SECTION A-A
(FINISH FLARE ONE END
AFTER ASSEMBLY)
SCALE 2X

D212-725-1-029 TUBING
(MANUFACTURE PER TEMPLATE DT8907)

NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL, 1.00 O.D. x 0.049 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF. DART SPEC. M304TR1.000W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.82 lbs

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV A
MFG. APPR.	JS	D4219	SHEET 2 OF 2
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	TUBE ASSEMBLY	NTS
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